

Work Order ID 55814 -1

Tuesday, February 02, 2010 1:17:18 PM

Page 1

split



Item ID: D3463-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Drag Arm

Start Date: 2/3/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 2/12/2010 Req'd Qty: 6.00

Customer:

Reference:

Run Start



Approvals: Process Plan: *mf*

Date: 10-2-2

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr Revision Nbr

D3463 Rev B

100



Small Fab

Small Fab

Small Fab

Memo

1-Cut to 13.875" 2-Deburr 3-Bend end as per dwg D3463

0.00

0.00

SP 10/02/03

(6)

L-SAW 10-02-03 2 Extra

110



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

=> 10/02/04

(46)

120



Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

Memo

1-Mill as per dwg D3463 2-Drill hole & ream to 0.4385" as per dwg D3463 3-Deburr

0.00

0.00

SP 10/02/06

(4)

2

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Item ID: D3463-7

Accept

Setup Start

Revision ID:

Stop

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Start Date: 2/3/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 2/12/2010 Req'd Qty: 6.00

Customer:

Reference:

Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC2- Inspect parts off machine FAI/FAIB

0.00

27 13/02/06

QC

Memo

0.00

Quality Control

140

QC8- Inspect parts - second check

0.00

Ind 10.07.10

(4)

QC

Memo

0.00

Quality Control

150

Small Fab

0.00

SAD

10-02-10

(4)

Small Fab

Memo

Small Fab

Grind .450" rad

0.00

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Item ID: D3463-7

Accept

Setup Start

Revision ID:

Stop

Item Name: Drag Arm

Start Date: 2/3/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 2/12/2010 Req'd Qty: 6.00

Customer:

Reference:

Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

2/10/2/10

4

170

Identify as per dwg & Stock Location: ~~W4625A~~

0.00



Packaging

Memo

W4625A

0.00

Packaging

4

10/02/10

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/11
MF
10-2-11

Picklist Print

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Page 1

Work Order ID: 55814

Parent Item: D3463-7

Parent Item Name: Drag Arm

Comments: IPP REV> A 05.11.18 new issue EC
IPP Rev:B Added Step 7 08-11-04 JLM Verified By:EC

Start Date: 2/3/2010

Required Date: 2/12/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TR0.750W.120		Purchased	No			100	f	11.6553	6.0000	6.91	10/02/09	

M304TR0.750W.120

304 ss round tube .750 x .120w

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

11.6553

111096

9.6948

111097

1.9605

1 Part = 1.1663

6.90 + 2.313
↑ ↑
6 parts 2 parts

SAD 10-02-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

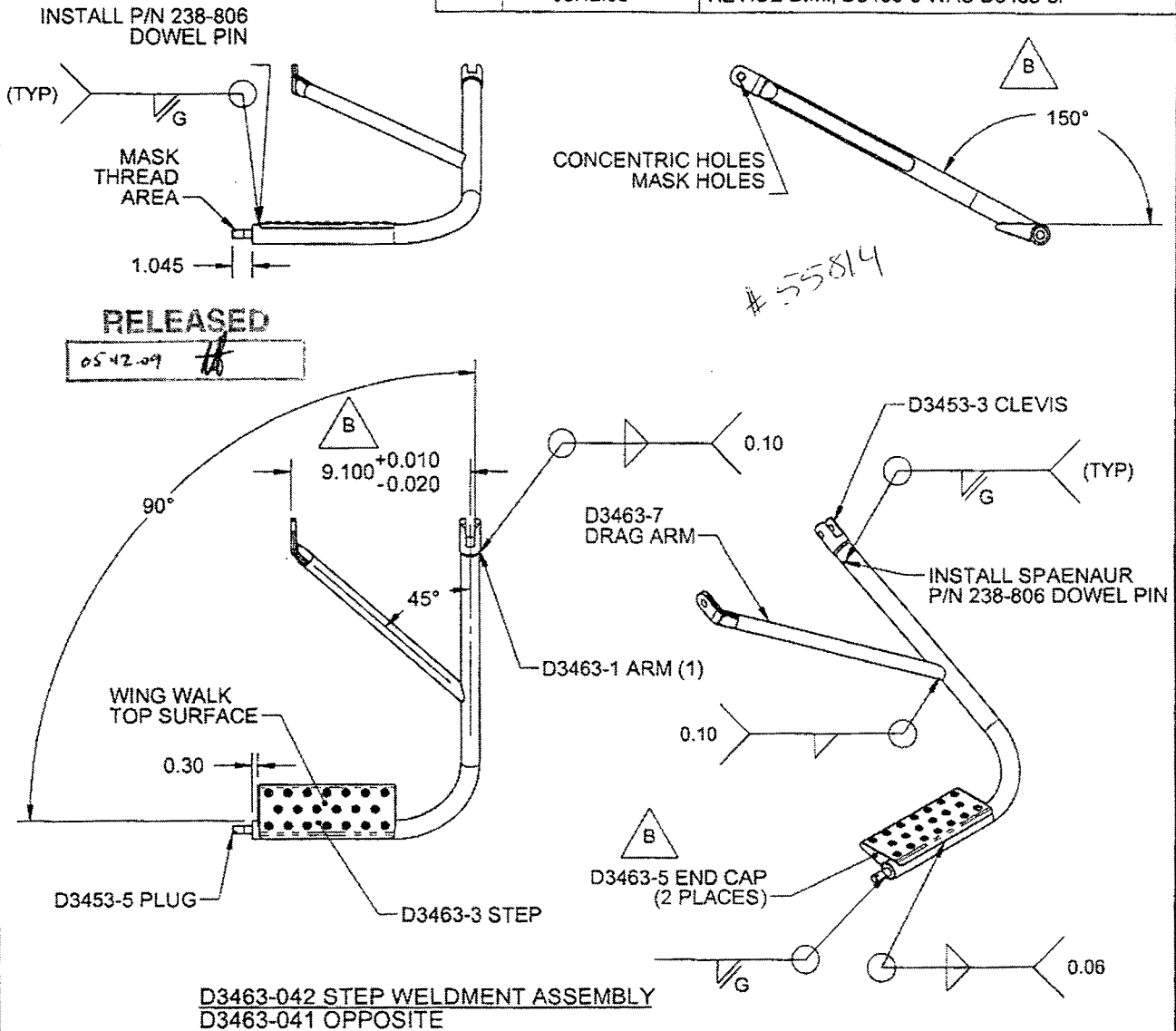
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 1 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:8
A	05.09.20	NEW ISSUE	
B	05.12.05	REVISE DIM.; D3463-5 WAS D3463-5F	

**NOTES:**

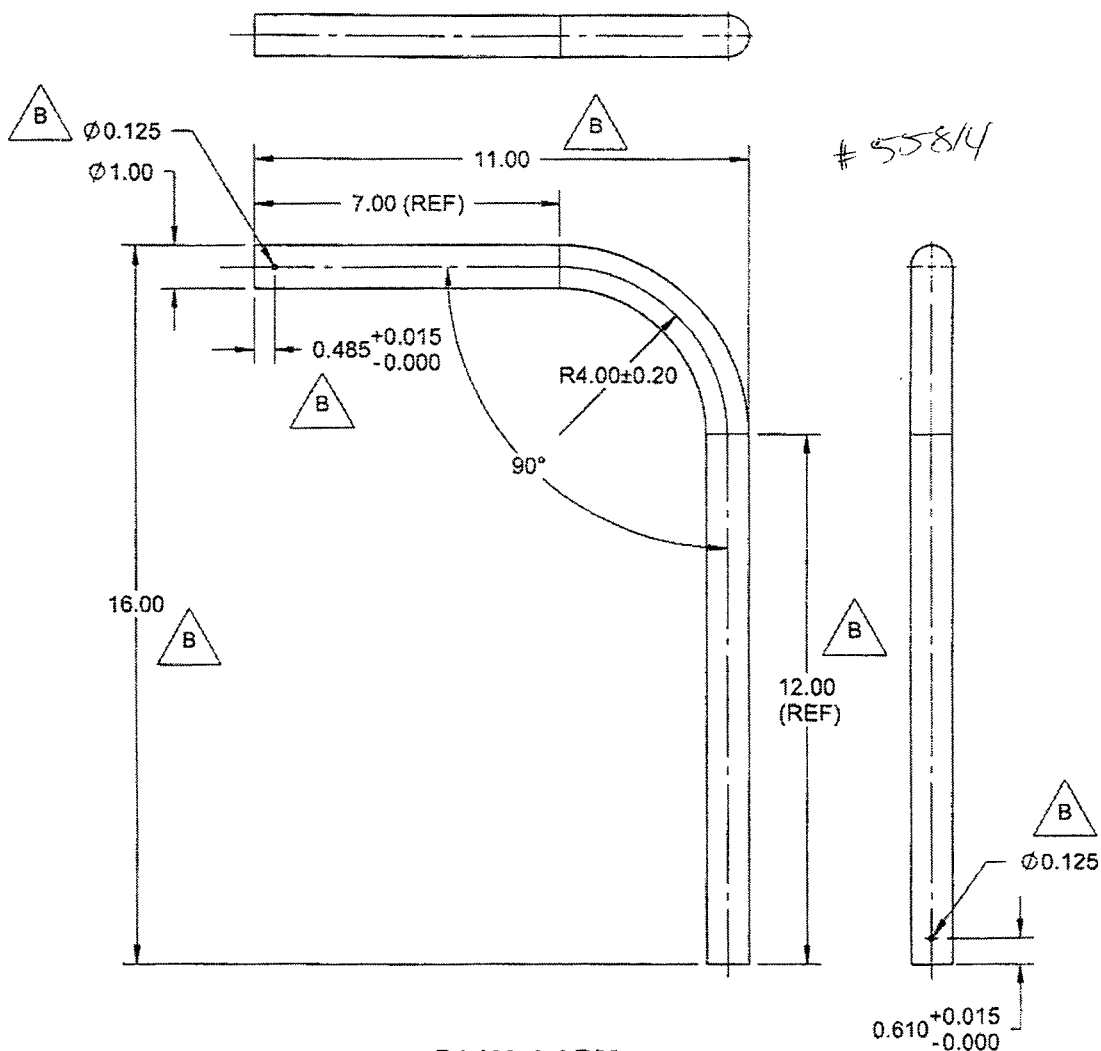
- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3463	REV. B SHEET 2 OF 4
DATE 05.12.05		TITLE STEP WELDMENT	SCALE 1:4

05.12.09



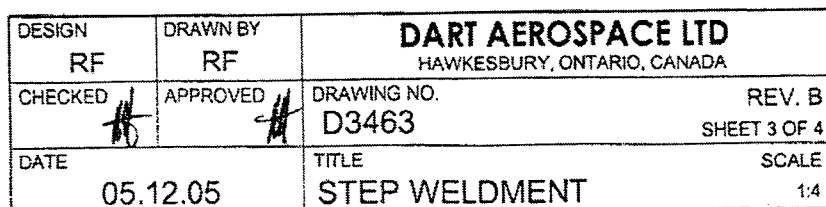
D3463-1 ARM

NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W.120)
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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05.12.04



1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W.120)
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

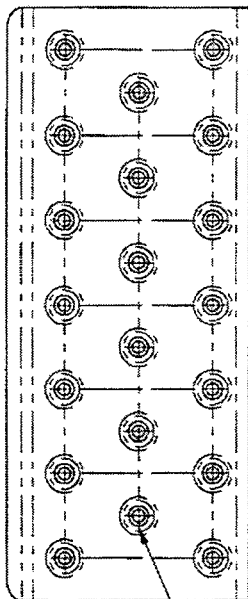
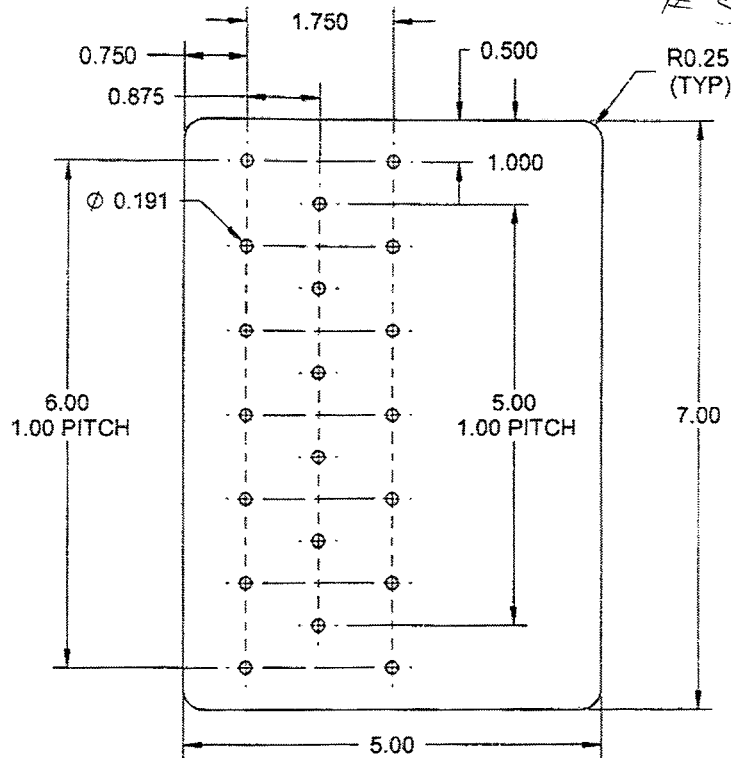
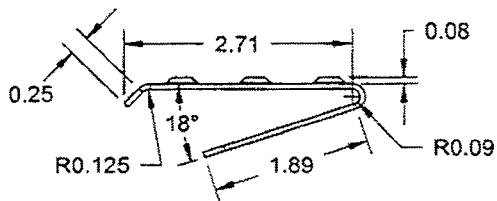
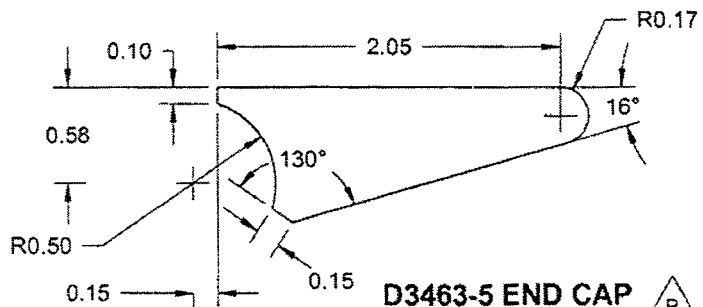
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DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 4 OF 4
DATE 05.12.05		TITLE STEP WELDMENT	SCALE 1:2

RELEASED

05.12.09 #

FORM USING
D3463-3T1**D3463-3F FLAT PATTERN****D3463-3 STEP****D3463-5 END CAP**
SCALE 1:1**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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